

IN THE CLAIMS:

Please replace the paragraph containing the single word CLAIMS, beginning at Page 8, line 1 with the following rewritten paragraph:

WHAT IS CLAIMED IS:

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1. (Currently Amended) Multi-stand photogravure machine comprising: with a first ~~(10)~~ printing unit containing an impression roller and a driven print cylinder, and at least one additional printing unit, ~~(12a, 12b)~~ each including: containing an impression roller in contact with a printable material, ~~(32, 52)~~ and a driven contacting print cylinder, and ~~(34, 54)~~, characterized in that, in the at least one additional printing unit ~~(12a, 12b)~~, the impression roller ~~(52)~~ is provided with a regulated drive ~~(56)~~ and is in contact with the printable material ~~(16)~~, so that it can associated with the impression roller to sustain a web velocity of the printable material ~~(16)~~ varying from the a circumferential speed of the contacting print cylinder ~~(54)~~.

2. (Currently Amended) Multi-stand photogravure machine of claim 1, wherein characterized in that, in the at least one additional printing unit (12a), the regulated drive (56) of associated with the impression roller (52) contains includes a metering roll (48), which is disposed adjacent to ~~the~~ a course of the web and measures the web tension.

3. (Currently Amended) Multi-stand photogravure machine of claim 1, wherein or 2, characterized in that each driven impression roller (52) has a drive, in which an acceleration or deceleration can be set with respect to another impression roller (32).

4. (Currently Amended) Multi-stand photogravure machine of claim 1, wherein one of the preceding claims, characterized in that the print cylinder (54) of the at least one additional printing unit (12a, 12b) has includes a drive, in which an acceleration or deceleration with respect to the print cylinder (34) of the first printing unit (10) can be set.

5. (Currently Amended) Photogravure process for a multi-stand photogravure machine including with a first (10) printing unit containing an impression roller and a driven print cylinder, and at least one additional printing unit (12a, 12b), each

additional printing unit including containing an impression roller (32, 52) and a driven print cylinder, (34, 54),
characterized in that the process comprising the steps of:
actively driving the impression roller (52) of the at least one additional printing unit (12a, 12b) is actively driven and that, by means of the
regulating the web tension of a web by a drive of the impression roller (52) of the at least one additional printing unit (12a, 12b), the web tension of a web (16) is regulated.

6. (Currently Amended) Photogravure process of claim 5,
further comprising the steps of: characterized in that,
setting the web velocity, upon the start-up of the photogravure machine, when the print cylinders (34, 54) are brought to a uniform, regulated rotational speed, the web velocity is set by a draw-in mechanism, (14) and regulating the rotational speed of each driven impression roller (32, 52) is so regulated such that a uniform web tension results in all printing units (10, 12a, 12b).

7. (Currently Amended) Photogravure process of claim 5 or 6, further comprising the steps of: characterized in that,
setting the web velocity, upon start-up, of the impression roller (32) of the printing unit (10) adjacent to one a draw-in mechanism (14) sets the web velocity, and

regulating the rotational speed of a draw-in mechanism (14) and impression roller (52) of the at least one additional printing unit (12a, 12b) are regulated, so that a uniform web tension results.

8. (Currently Amended) Photogravure process of claim one of the claims 5 to 7, further comprising the step of: characterized in that,

regulating, during start-up, the rotational speed of the print cylinder (54) in the at least one additional printing unit (12a, 12b) is regulated by means of an optical sensor (58) so that register accuracy is achieved.

9. (Currently Amended) Photogravure process of claim one of the claims 5 to 8, further comprising the steps of: characterized in that,

sustaining, during ~~the~~ a run time, the rotational speeds of the impression rollers (32, 52) attained in the start-up are ~~sustained~~, and

making a reaction is made to departures from ~~the~~ a uniform web tension with brief variations of a set speed of a driven impression roller (52) from the rotational speed reached during start-up.

10. (Currently Amended) Photogravure process of claim one of the claims 5 to 9, further comprising the steps of: characterized in that,

sustaining, during a run time, the speeds of the print cylinders (34, 54) reached during start-up ~~are sustained~~, and making a reaction ~~is made~~ to register errors with brief departures of a set speed from the speed reached during start-up.

11. (Currently Amended) Photogravure process of claim 9, characterized in that, wherein the step of making a reaction to departures to produce the brief ~~departure~~ variations of the set speed of a driven impression roller (52), includes the step of establishing an acceleration or deceleration with respect to another impression roller (32) ~~is established~~ at the drive of the other impression roller (52).

12. (Currently Amended) Photogravure method of claim 10, characterized in that, wherein the step of making a reaction to produce the brief departure of the set speed of a print cylinder (54), includes the step of establishing an acceleration or deceleration, with respect to another print cylinder (34), ~~is established~~ at the drive of the other print cylinder (54).